

Date: Monday, 12/19/2005 11:13:28 AM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BRACKET ASSEMBLY	
Job Number	: 25285				
Estimate Number	: 11519				
P.O. Number	: N/A		Part Number	: D3152042	
This Issue	: 12/19/2005 S.O. No. : N/A		Drawing Number	: D3152 REV B	
Prsh Rev.	: NC		Project Number	: N/A	
First Issue	: N/A		Drawing Revision	: B	
Previous Run	: N/A		Material	: N/A	
Written By	: See comment below		Due Date	: 12/23/2005	
Checked & Approved By	: See comment below		Qty:	12	
Comment	: Est Rev:B Removed Purchasing 05-12-19 JLM		Um:	#	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D31524	Seal	
		12	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)	
		Pick:	
		Qty Part # Description Batch: (7) m18159	
		1 D3152-4 Seal (5) m10536-17	
2.0	D31522	Bracket	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)	
		Pick:	
		Qty Part # Description Batch:	
		1 D3152-2 Bracket (12) B18867	
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1	
		Bond D3152-3 Seal to D3152-1 Bracket using RTV 732 per Dwg D3152. RTV 732 Black	
		Batch: m16368	
		Expiry: 17 Feb 2007	
		Identify as D3152-041	
4.0	QC5	INSPECT WORK TO CURRENT STEP	
		Comment: INSPECT WORK TO CURRENT STEP	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 06/01/18
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 12/19/2005 11:13:28 AM
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Drawing Name: BRACKET ASSEMBLY

Job Number: 25285

Part Number: D3152042

Job Number:



Seq. #:	Machine Or Operation:	Description :
5.0	PACKAGING 1	PACKAGING RESOURCE #1
<p>Comment: PACKAGING RESOURCE #1 Identify and Stock Location: _____</p> <p>Morinak 6/1/18 (12)</p>		
6.0	DC	DOCUMENT CONTROL
<p>Comment: DOCUMENT CONTROL 5/25/18 (12) SP 06/18</p>		

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
		D3152	SHEET 1 OF 2
DATE	TITLE	SCALE	
04.10.18	BRACKET ASSEMBLY	1:1	
A	02.04.24	NEW ISSUE	
B	04.10.18	ADD PART MARKING & RTV 732 BLACK	

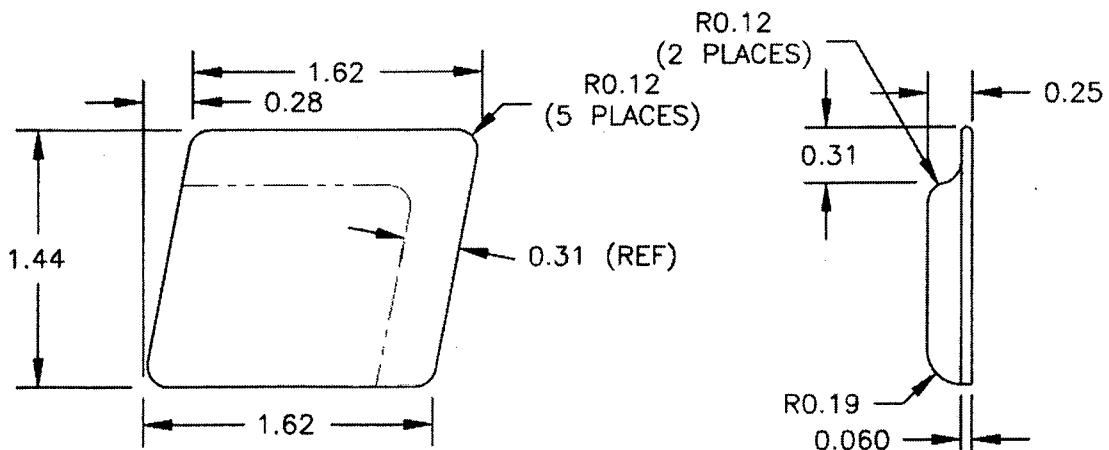
RELEASED
*04/11/23***D3152-041 BRACKET ASSEMBLY****D3152-042 BRACKET ASSEMBLY**

IDENTIFY WITH DART P/N
USING FINE POINT PERMANENT
INK MARKER

D3152-3 (-041)
or D3152-4 (-042)

BOND D3152-3/-4(OPP) SEAL TO
D3152-1/-2(OPP) BRKT USING
RTV 732 CLEAR (A/R)
OR RTV 732 BLACK (A/R)

D3152-1 (-041)
or D3152-2 (-042)

**D3152-3 SEAL (SHOWN)****D3152-4 SEAL (OPPOSITE)**

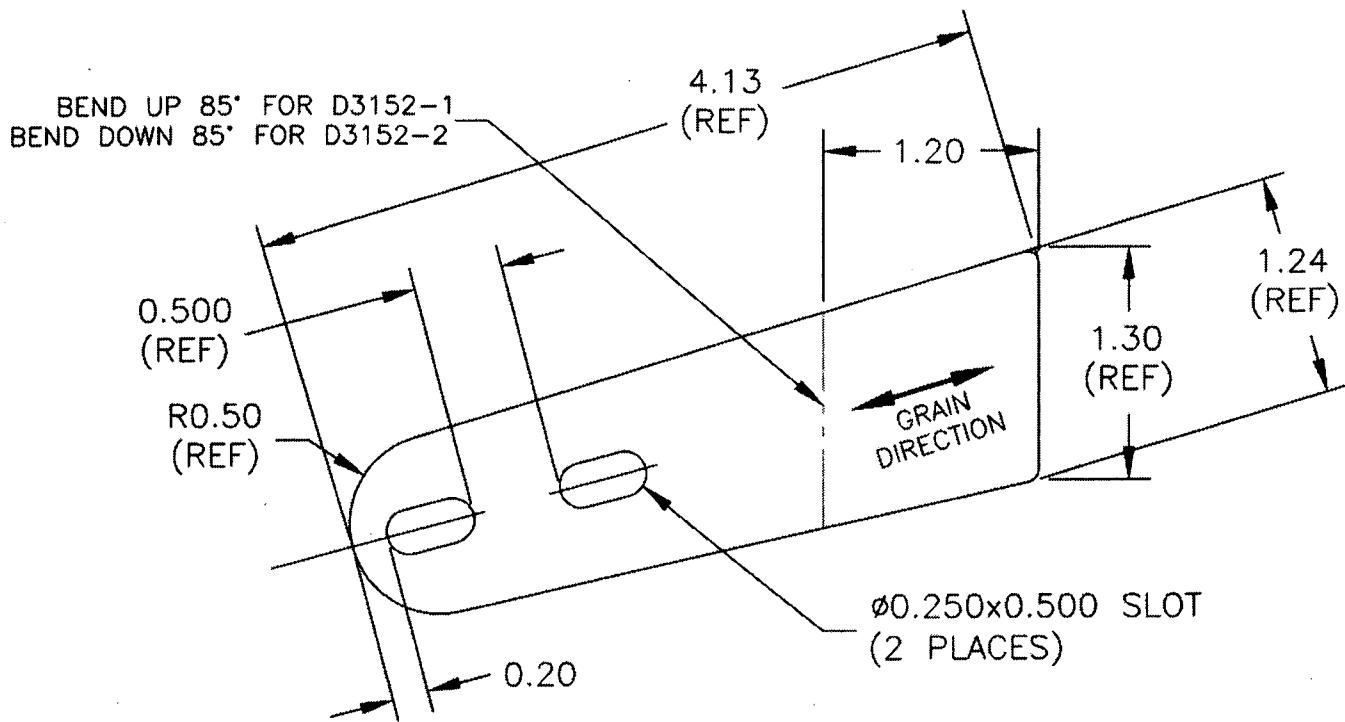
1. D3152-3 REPLACES PREMIER P/N B30-23000-243
2. D3152-4 REPLACES PREMIER P/N B30-23000-244
3. MAKE D3152-3 PER TOOL # B30-23000-243T
4. MAKE D3152-4 PER TOOL # B30-23000-244T
5. MATERIAL: RTV 732 BLACK
6. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
7. ALL DIMENSIONS ARE IN INCHES

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DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
DATE	04.10.18	TITLE	SHEET 2 OF 2 SCALE 1:1

RELEASED
04.10.23**D3152-1/-2 BRACKET**

1. D3152-1 REPLACES PREMIER P/N B30-23000-223
D3152-2 REPLACES PREMIER P/N B30-23000-224
2. MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (REF DART SPEC. M2024T3S.063)
3. FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
4. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5. ALL DIMENSIONS ARE IN INCHES
6. BREAK ALL SHARP EDGES 0.005 TO 0.010
7. MACHINE PER DWG FILE "D3152-B2.DWG"